

43

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	21560
<b>Description:</b> Bracket	<b>Part Number:</b>	D3228-041/-042 D3228-043/ <u>044</u>
<b>Dwg:</b> D3228 Rev. A	<b>Qty:</b>	4 Kits
D3228-041/-042 replaces Helitech P/N: 358-011-001/-002		Page 1 of 2
D3228-043/-044 replaces Helitech P/N: 358-012-001/-002		

Step	Location	Procedure	By	Date	Qty						
1	DC	Issue Traveller <b>Note: Each Kwik Float Kit consists of (2) D3228-041; (2) D3228-042; (2) D3228-043; (2) D3228-044</b>	HA	04.09.23	4						
2	MV	<b>Cut (8) blanks: 1.250" x 1.500" x 6.975" long (+/- 0.030) per Kit.</b> Material: 6061-T6/T651 (QQ-A-200/8 or QQ-A-250/11 (M6061T6B1.500x01.250) <b>Identify for D3228-1/2/3/4</b> Batch: <b>M7203</b>	EP	04/12/15	4						
3	MV	Machine (2) D3228-1 per Kit as per Folio FA367 & Dwg D3228 <b>Identify as D3228-1</b>									
4	QC2	Inspect parts as they come off the CNC machine									
5	MV	Deburr and break all sharp edges 0.005"-0.010"									
6	QC8	Second inspection									
7	MV	Machine (2) D3228-2 per Kit as per Folio FA367 & Dwg D3228 <b>Identify as D3228-2</b>									
8	QC2	Inspect parts as they come off the CNC machine									
9	MV	Deburr and break all sharp edges 0.005"-0.010"									
10	QC8	Second inspection									
11	MV	Machine (2) D3228-3 per Kit as per Folio FA367 & Dwg D3228 <b>Identify as D3228-3</b>									
12	QC2	Inspect parts as they come off the CNC machine									
13	MV	Deburr and break all sharp edges 0.005"-0.010"									
14	QC8	Second inspection									
15	MV	Machine (2) D3228-4 per Kit as per Folio FA367 & Dwg D3228 <b>Identify as D3228-4</b>	EP	04/12/17	4						
16	QC2	Inspect parts as they come off the CNC machine	EP	04/12/17	4						
17	MV	Deburr and break all sharp edges 0.005"-0.010"	EP	04/12/17	4						
18	QC8	Second inspection	ML	04/12/17	4						
19	FP	Chemical Conversion Coat as per QSI 005 4.1 D3228-1/-2/-3/-4	ML	05 01 03	4						
20	FP	Powder Coat Gloss White (Ref: 4.3.5.1) per Dart QSI 005 4.3 D3228-1/-2/-3/-4	ML	05 01 12	4						
21	QC3	Inspect Powder Coat	EP	05-01-13	4						
22	GA	Fabricate (4) D3228-5 (make from D2397) per Kit. <b>Pick:</b> <table><tr><td><u>Part Number</u></td><td><u>Description</u></td><td><u>Batch</u></td></tr><tr><td>D2397</td><td>Rubber Cushion</td><td></td></tr></table> <b>Identify as D3228-5</b>	<u>Part Number</u>	<u>Description</u>	<u>Batch</u>	D2397	Rubber Cushion				
<u>Part Number</u>	<u>Description</u>	<u>Batch</u>									
D2397	Rubber Cushion										

RELEASED

03.11.27

**DART**

1.441

1.000

D3228-041 BR  
D3228-042 BR**RELEASED**

03.12.05

D3228-041/-042 BRACKET

1) MATERIAL:

D3228-1/-2: 601  
D3228-5: MAKE F2) FINISH: CHEMICAL CONVER  
POWDER COAT WH

3) BREAK ALL SHARP EDGES

4) ALL DIMENSIONS ARE IN II

5) TOLERANCES ARE PER DAI

6) ENGRAVE P/N AND LETTEF

7) INSTALL D3228-5 PACKER

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OR COMMUNICAT**DART AEROSPACE LTD**

Work Order:

21560

Description: Bracket

Part Number:

D3228-041/-042

D3228-043/-044

Dwg: D3228 Rev. A

Qty:

4 Kits

D3228-041/-042 replaces Helitech P/N: 358-011-001/-002

Page 2 of 2

D3228-043/-044 replaces Helitech P/N: 358-012-001/-002

Step	Location	Procedure	By	Date	Qty
23	GA	Fabricate (4) D3228-7 (make from D2397) per Kit . <b>Pick:</b> <u>Part Number</u> <u>Description</u> <u>Batch</u> D2397      Rubber Cushion      B16915 <b>Identify as D3228-7</b>		2 05-01-13	4
24	GA	Assemble (2) D3228-041 as per Dwg D3228. (Note: D3228-1 & -5 are on BOM as material from Step 2 & 22) <u>Qty</u> <u>Part Number</u> <u>Description</u> <u>Batch</u> 2      D3228-1      Bracket 2      D3228-5      Packer A/R      Contact Cement <b>Identify as D3228-041</b>			
25	GA	Assemble (2) D3228-042 as per Dwg D3228. (Note: D3228-2 & -5 are on BOM as material from Step 2 & 22) <u>Qty</u> <u>Part Number</u> <u>Description</u> <u>Batch</u> 2      D3228-2      Bracket 2      D3228-5      Packer A/R      Contact Cement <b>Identify as D3228-042</b>			
26	GA	Assemble (2) D3228-043 as per Dwg D3228. (Note: D3228-3 & -7 are on BOM as material from Step 2 & 23) <u>Qty</u> <u>Part Number</u> <u>Description</u> <u>Batch</u> 2      D3228-3      Bracket 2      D3228-7      Packer A/R      Contact Cement <b>Identify as D3228-043</b>			
27	GA	Assemble (2) D3228-044 as per Dwg D3228. (Note: D3228-4 & -7 are on BOM as material from Step 2 & 23) <u>Qty</u> <u>Part Number</u> <u>Description</u> <u>Batch</u> 2      D3228-4      Bracket      B21560 2      D3228-7      Packer      B16915 A/R      Contact Cement      M11854 <b>Identify as D3228-044</b>		2 05-01-13	4
28	QC5	Inspect work to Step 27	U	05-01-17	4
29	ST	Identify and Stock in Kwik Float Cell D3228-041 Qty: 4 D3228-042 Qty: 4 D3228-043 Qty: 4 D3228-044 Qty: 4		05-01-17	4
30	AC	Parts to Stock and Prorate cost to parts per Step 29 Cost / part 47.95	SAC	05-01-18	4
31	DC	Close W/O 47.95 Inspect Level 21	HA	05-01-25	4

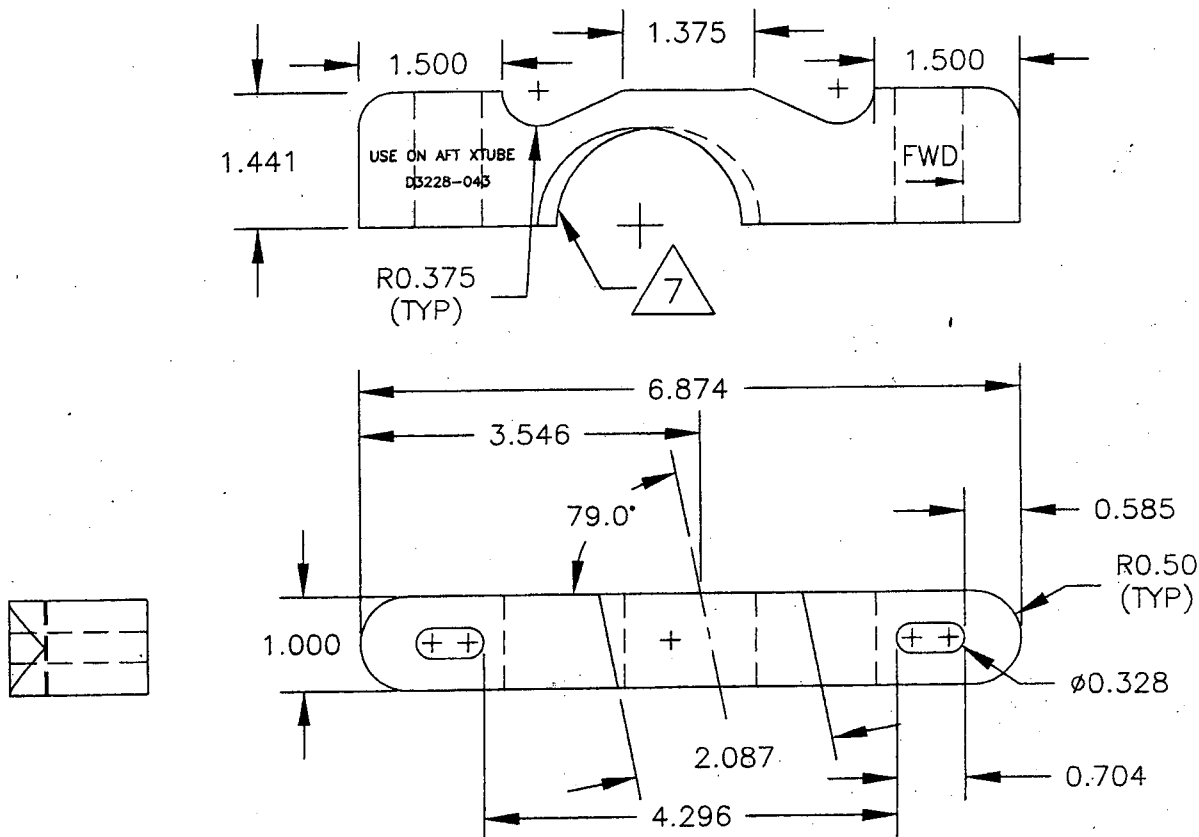
Rev	Date	Change	Revised By	Approved
A	03.11.11	New issue	KJ/JLM/DS	

**RELEASED**

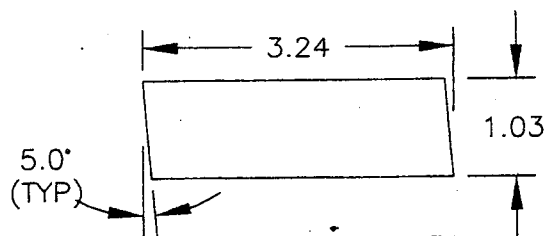
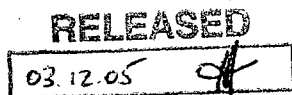
03 11 27



DESIGN H	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3228	REV. A SHEET 2 OF 2
DATE 03.10.28		TITLE BRACKET	SCALE 1:2



D3228-043 BRACKET (SHOWN. REPLACES HELITECH P/N 358-012-001)  
D3228-044 BRACKET (OPPOSITE. REPLACES HELITECH P/N 358-012-002)



D3228-7 PACKER

7 TACKLER  
SHOP COPY

RETURN TO  
ENGINEERING

UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE

WORK ORDER

NO. 2156c

D3228-043/-044 BRACKET (D3228-4/-3 BRACKET, D3228-7 PACKER)

1) MATERIAL:

D3228-3/-4: 6061-T6/T651 ALUMINUM (QQ-A-200/8 OR QQ-A-250/11)  
D3228-7: MAKE FROM D2397

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3

3) BREAK ALL SHARP EDGES 0.005 TO 0.010

4) ALL DIMENSIONS ARE IN INCHES

5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

6) ENGRAVE P/N AND LETTERING AS SHOWN

7) INSTALL D3228-7 PACKER ON THIS SURFACE AFTER PAINT USING CONTACT CEMENT

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# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Sep 22, 2004  
03:57 pm

Work Order No : 0021563  
Project Name : D3228-044  
Project For : WK443  
Work Order Type : Main  
Main WO Number :  
House Part Number : D3228-044  
Description : Bracket Assembly  
Manufactured : Yes  
Amount Req'd : 4  
Amount Done : 0  
Start Date : 09-22-04  
Est Finish Date : 10-23-04  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
Order Entry No :  
OE Value : 0.00  
Est Margin : 0.000%  
Actual Margin : 0.000%  
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

